

Work Order ID 52306

Tuesday, September 22, 2009 2:33:08 PM



Page 1

Item ID: D2665-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: PS Date: 09-9-22 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2665	Rev D								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program batch number. ☐ 1- Inspect part number and batch number are programmed correctly. ☐ 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet ☐ 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

SL 09/10/14 (8)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

SL 09/10/14 (8)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 09/10/14 (8)

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Tuesday, September 22, 2009 2:33:08 PM



Page 2

Item ID:	D2665-1	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	Saddle, LH Fwd Aft Out 206					
Start Date:	9/23/2009	Start Qty:	8.00	Cust Item ID:		
Required Date:	10/9/2009	Req'd Qty:	8.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>8/09/10/14</i>			<i>8</i>	<i>0</i>		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	<i>9/10/14</i>			<i>(18)</i>	<i>0</i>		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M112260</i> Memo START TIME: <i>7:15AM</i> OVEN TEMPERATURE: <i>7:45pm</i> FINISH TIME: <i>3:20pm</i>	0.00 0.00	<i>=> 9/10/15</i>			<i>(48)</i>	<i>0</i>		

Work Order ID 52306

Tuesday, September 22, 2009 2:33:08 PM



Page 3

Item ID: D2665-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

BR 09-10-15

(8)

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 436

0.00



Packaging

Memo

0.00

Packaging

9/10/16 (8) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19 AJ

MF
09-10-19

Picklist Print

Tuesday, September 22, 2009 2:33:08 PM

Page 1

Work Order ID: 52306



Parent Item: D2665-1RevD



Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-003RevB		Manufactured	No			100	Each	0.0000	8.0000			

Saddle Billet, 7075

B 46410 X 8.0 JL 09/10/14

DART AEROSPACE LTD	Work Order:	52306
Description: 206 Saddle, Outboard, Left side	Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.115	.117	.121	.120		
B	0.100	0.140		.129	.128	.125	.126		
C	1.125	1.145		1.133	1.137	1.140	1.137		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.254	.251	.248	.251		
F	1.313	1.343		1.327	1.328	1.327	1.327		
G	0.210	0.230		.220	.220	.220	.220		
H	0.100	0.180		.125	.125	.125	.125		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.571	1.575	1.577	1.573		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.116	.115	.115	.115		
M	0.990	1.010		1.001	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.547	.549	.549	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.502	.500	.499	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	09/10/13

Audited by:	85
Date:	09/10/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 52306
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.100	0.140		.120	.119	.120	.120		
B	0.100	0.140		.121	.125	.127	.127		
C	1.125	1.145		1.137	1.137	1.136	1.138		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.251	.251	.251	.251		
F	1.313	1.343		1.327	1.326	1.327	1.327		
G	0.210	0.230		.221	.220	.220	.221		
H	0.100	0.180		.125	.125	.125	.125		
I	2.470	2.510		2.490	2.490	2.490	2.490		
J	1.565	1.585		1.575	1.574	1.574	1.575		
K	0.235	0.240		.238	.238	.238	.238		
L	0.100	0.120		.115	.115	.116	.115		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515		.510	.510	.510	.510		
O	5.990	6.010		6.000	6.000	6.000	6.000		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	.314	.314	.314		
S	0.315	0.322		.319	.319	.319	.319		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	.797	.797		
W	0.540	0.560		.550	.549	.550	.549		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.912	0.932		.920	.920	.920	.920		
AA	0.490	0.510		.500	.502	.499	.500		
AB	0.178	0.198		.188	.188	.188	.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SL
Date:	09/10/14

Audited by:	RF
Date:	09/10/14

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

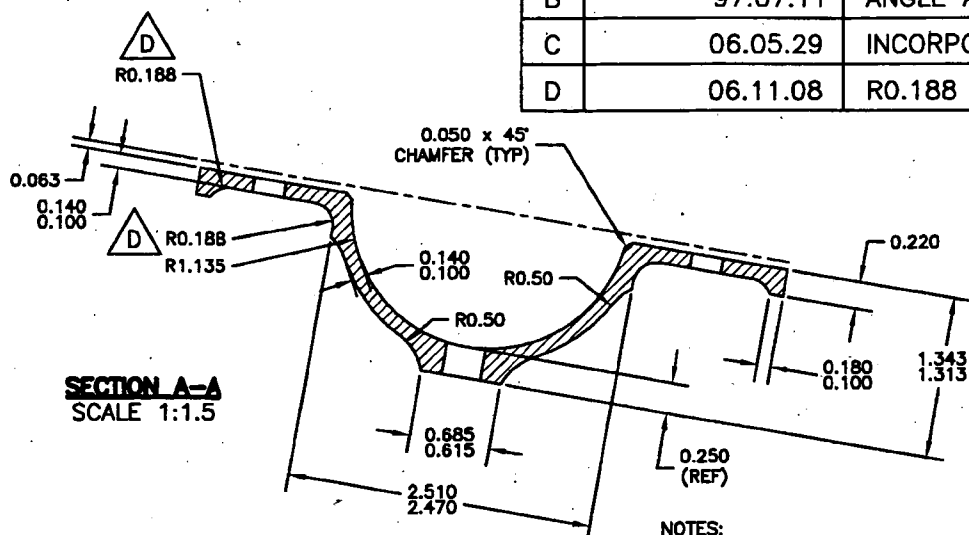
SHOP COPY
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 ENGINEER
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DART

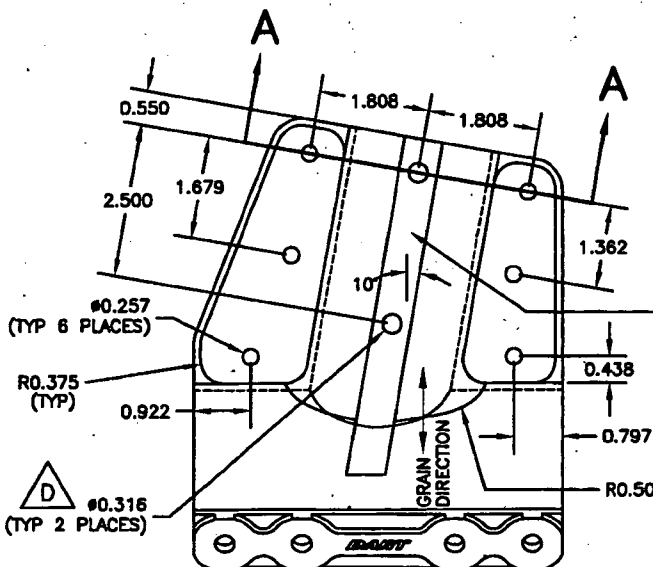
SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
		PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2665	SHEET 1 OF 1
DATE	TITLE		SCALE
06.11.08	SADDLE FWD OUTSIDE HIGH		1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	

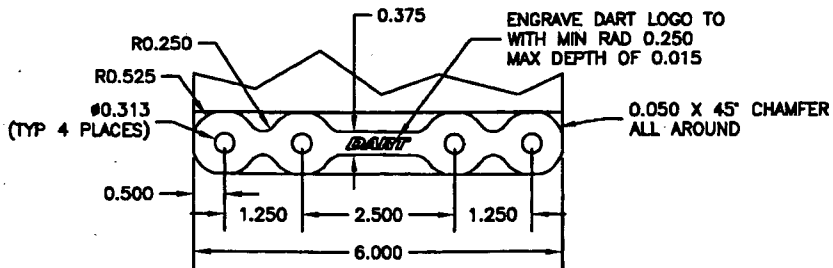
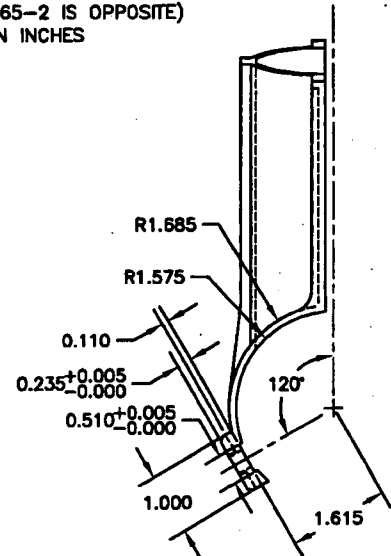
RELEASED
 07.02.12



- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
 - 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
 NUMBER AND
 BATCH NUMBER
 TO MAX DEPTH
 OF 0.010 WITH
 MIN RADIUS
 OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH